



Microfinish Mold & Tool Finish Guide

SPI Finish Designation	Preparation Guideline	Approximate Resulting Ra (microinches)
A1	#3 Diamond Buff	0 to 1
A2	#6 Diamond Buff	1 to 2
A3	#15 Diamond Buff	2 to 3
B1	600 Grit Paper	2 to 3
B2	400 Grit Paper	4 to 5
B3	320 Grit Paper	9 to 10
C1	600 Grit Stone	10 to 12
C2	400 Grit Stone	25 to 30
C3	320 Grit Stone	35 to 45
D1	#11 Glass Bead	Undeterminable
D2	240 Grit Aluminum Oxide	Undeterminable
D3	24 Grit Aluminium Oxide	Undeterminable